

Date: Wednesday, 4/5/2006 3:32:18 PM  
 User: Kim Johnston

## Process Sheet

|   |                                      |
|---|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services            | Drawing Name : AFT TUBE ASSEMBLY     |
| Job Number : 26579  |                                      |
| Estimate Number : 10699                                   |                                      |
| P.O. Number : <u>NIA</u>                                  | Part Number : D3391025               |
| This Issue : 4/5/2006 S.O. No. : <u>NIA</u>               | Drawing Number : D3391 REV D         |
| Prsht Rev. : NC   | Project Number : N/A                 |
| First Issue : <u>NIA</u> Type : LANDING GEAR              | Drawing Revision : D                 |
| Previous Run : 26578                                      | Material : <u>NIA</u>                |
| Written By : <u>See comment below</u>                     | Due Date : 4/24/2006 Qty: 1 Um: Each |
| Checked & Approved By : <u>06.04.06</u>                   |                                      |
| Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC         |                                      |
| Est Rev: C 06-03-28 Update Manufacturing Instructions JLM |                                      |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |          |                    |
|-----|----------|--------------------|
| 1.0 | D6014090 | ALUMINUM EXTRUSION |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 24315Identify as D3391-3 D6014-104

MS 06/04/20 1

|     |            |                            |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: AA & Dwg D3391 Rev: D

MS 06/04/21 1

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 06/04/21 1

|     |       |                                |
|-----|-------|--------------------------------|
| 4.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: D

2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

MS 06/05/10 1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Wednesday, 4/5/2006 3:32:18 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26579

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*9ml 06/05/10*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*in 06/05/10 x*

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

*DP 06-5-25*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 06-5-25*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

*> DP 06-5-25*

*DP 06-5-26*

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 06-05-29*

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*BT 06-05-29*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 4/5/2006 3:32:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26579

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*am 06-06-14 (1)*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*DL 06/06/14 (1)*

14.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

| Qty | Part Number | Description | Batch         |
|-----|-------------|-------------|---------------|
| 14  | AESS10KB366 | Insert      | <i>M17905</i> |

15.0

NAS1330C3KB166



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

| Qty | Part Number    | Description | Batch          |
|-----|----------------|-------------|----------------|
| 8   | NAS1330C3KB166 | Insert      | <i>M100732</i> |

16.0

AESS10KB266

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

| Qty | Part Number       | Description | Batch         |
|-----|-------------------|-------------|---------------|
| 2   | AESS10KB266       | Insert      | <i>M17905</i> |
|     | or NAS1330C3KB266 |             |               |

17.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

| Qty | Part Number       | Description | Batch         |
|-----|-------------------|-------------|---------------|
| 2   | AESS10KB316       | Insert      | <i>M17905</i> |
|     | or NAS1330C3KB316 |             |               |

*DL 06/06/14 (1)*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 4/5/2006 3:32:19 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26579

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 1   | D2646       | Aft Cap     | B25381 |

19.0

AN3C4A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | AN3C4A      | Bolt        | M100651 |

20.0

AN960C10L

washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Pick:

| Qty | Part Number | Description | Batch  |
|-----|-------------|-------------|--------|
| 2   | AN960C10L   | Washer      | M18822 |

21.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

| Qty | Part Number | Description | Batch   |
|-----|-------------|-------------|---------|
| 2   | NAS1515H3L  | Washer      | M100186 |

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

DL 06/06/14 (1)

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291 M101197

Sikaflex expiry date: 11/09

DL 06/06/29 (1)

# Dart Aerospace Ltd

| W/O:     |      | WORK ORDER CHANGES                                     |    |          |     |                                     |                          |
|----------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE                                       | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 06.06.14 | 22   | QCS for inspection of inster + threads : installation. | M  | 06.06.15 | 1   |                                     |                          |
|          |      |  |    |          |     |                                     |                          |
|          |      |  |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: Date: 06/06/27.  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)  |                             |   |                |                           |                       |                          |
|----------|------|---|-----------------------------|---|----------------|---------------------------|-----------------------|--------------------------|
| DATE     | STEP | Description of NC<br>Section A  | Corrective Action Section B |   |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|          |      |   | Initial<br>Chief Eng        | Action Description<br>Chief Eng   | Sign &<br>Date |                           |                       |                          |
| 06.06.22 | 22.  | upon ASS'y, the Aft saddle<br>O.G. H-bung holes of the Aft +<br>Mid tube are slightly mis-Aligned.<br>R.C. : Pulled up when. weorplated<br>bolted on, 0620. |                             | Ream inner tube holes as<br>necessary. deburr, ensure<br>a proper fit, and touch-up<br>with Alcoline : Imvco white. | FC<br>06.06.28 | <br>06.06.28              |                       |                          |
|          |      |   |                             |   |                |                           |                       |                          |
|          |      |   |                             |   |                |                           |                       |                          |

NOTE: Date & initial all entries



Date: Wednesday, 4/5/2006 3:32:19 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 26579

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*ml* *OK OK 28* *(1)*

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A* *104/06/28*

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*Done 106/06/29* *(1)*

Job Completion



*u* *06-06-28*

**Dart Aerospace Ltd**

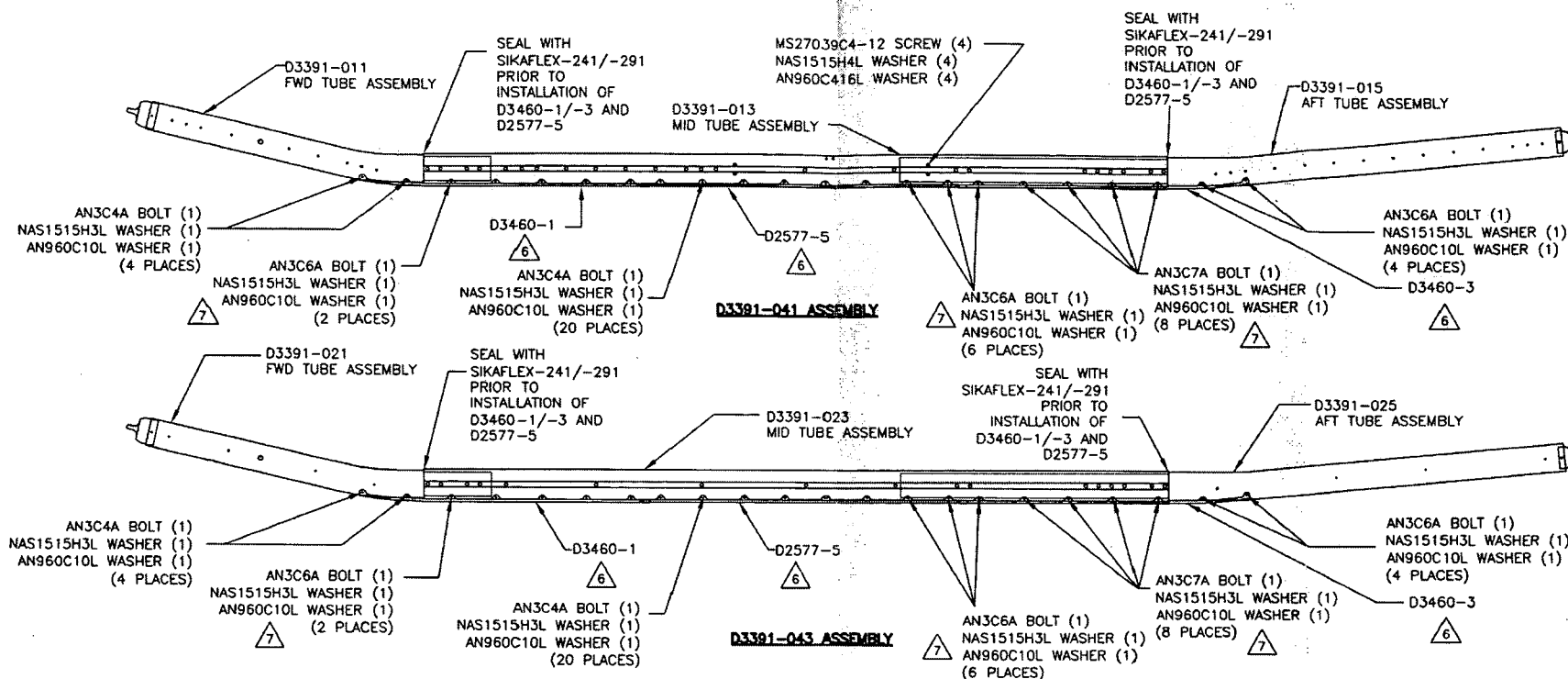
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# **D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

| QTY - 041 | QTY - 043 | PART NUMBER  | DESCRIPTION             |
|-----------|-----------|--------------|-------------------------|
| X         | X         | D3391-041    | FLOAT SKIDTUBE ASSEMBLY |
|           |           | D3391-043    | FLOAT SKIDTUBE ASSEMBLY |
| 1         |           | D3391-011    | FWD TUBE ASSEMBLY       |
| 1         |           | D3391-013    | MID TUBE ASSEMBLY       |
| 1         |           | D3391-015    | AFT TUBE ASSEMBLY       |
|           | 1         | D3391-021    | FWD TUBE ASSEMBLY       |
|           | 1         | D3391-023    | MID TUBE ASSEMBLY       |
|           | 1         | D3391-025    | AFT TUBE ASSEMBLY       |
| 24        | 24        | AN3C4A       | BOLT                    |
| 12        | 12        | AN3C6A       | BOLT                    |
| 8         | 8         | AN3C7A       | BOLT                    |
| 44        | 44        | NAS1515H3L   | WASHER                  |
| 44        | 44        | AN960C10L    | WASHER                  |
| 4         |           | MS27039C4-12 | SCREW                   |
| 4         |           | NAS1515H4L   | WASHER                  |
| 4         |           | AN960C416L   | WASHER                  |
| 1         | 1         | D2577-5      | WEARSHOE                |
| 1         | 1         | D3460-1      | WEARSHOE                |
| 1         | 1         | D3460-3      | WEARSHOE                |

## **GENERAL NOTES**

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS.  
C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

△

**RELEASED**

06.01.27

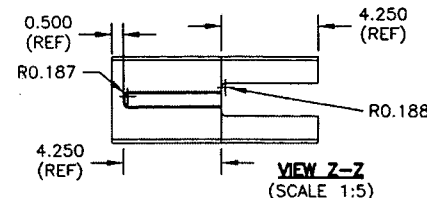
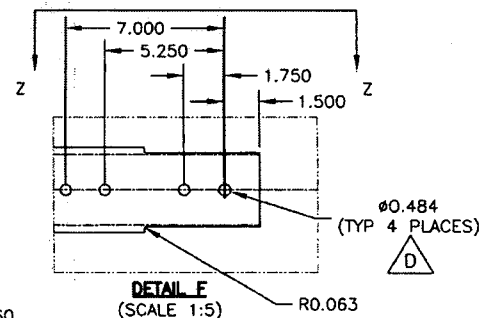
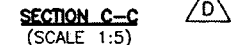
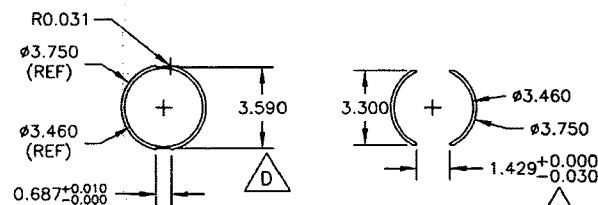
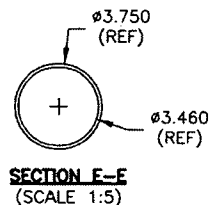
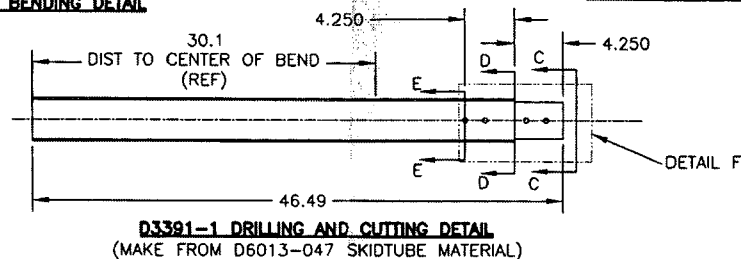
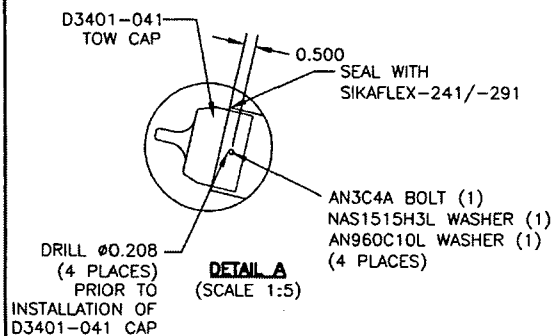
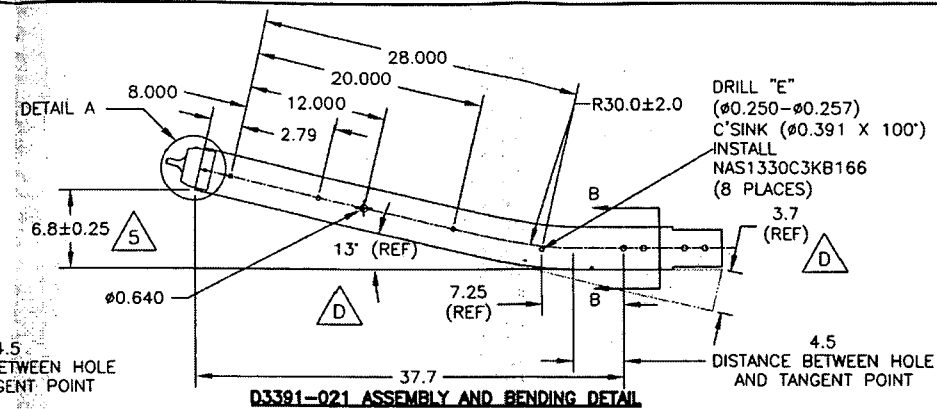
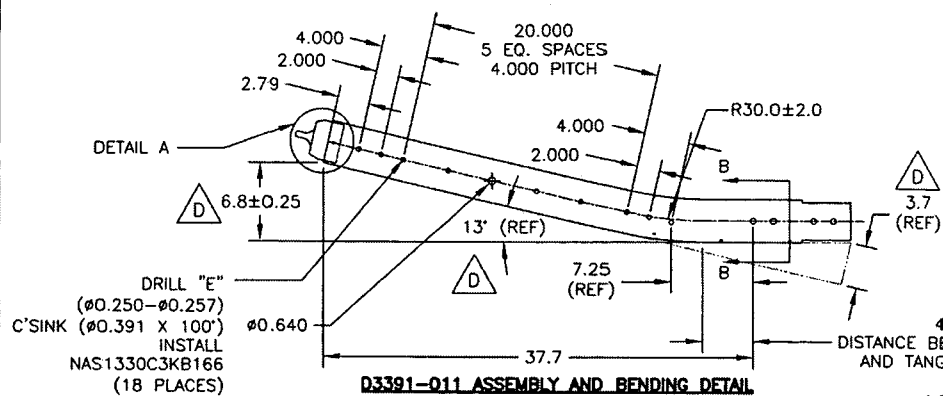
|         |          |                                    |
|---------|----------|------------------------------------|
| D       | 06.01.23 | UPDATE TOLERANCE, CHANGE HOLE SIZE |
| C       | 05.09.27 | LENGTHEN AFT EXTENSION             |
| B       | 05.06.10 | DRAWING UPDATES                    |
| A       | 05.02.07 | NEW ISSUE                          |
| DESIGN  | PH       | DRAWN BY                           |
| CHECKED | PH       | APPROVED                           |
| DATE    | 06.01.23 | TITLE                              |
|         |          | 412 FLOAT SKIDTUBE                 |
|         |          | REV. D                             |
|         |          | SHEET 1 OF 5                       |
|         |          | SCALE                              |
|         |          | NTS                                |

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PORT WASHINGTON, WA

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RETURN TO  
SHOP COPY  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
NO. 26579  
WORK ORDER



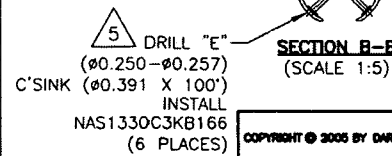
# D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

| QTY - 011 | QTY - 021 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         |           | D3391-011      | FWD TUBE ASSEMBLY |
|           | X         | D3391-021      | FWD TUBE ASSEMBLY |
| 1         | 1         | D6013-047      | FWD TUBE          |
| 1         | 1         | D3401-041      | TOW CAP           |
| 4         | 4         | AN3C4A         | BOLT              |
| 4         | 4         | NAS1515H3L     | WASHER            |
| 4         | 4         | AN960C10L      | WASHER            |
| 24        | 14        | NAS1330C3KB166 | INSERT            |

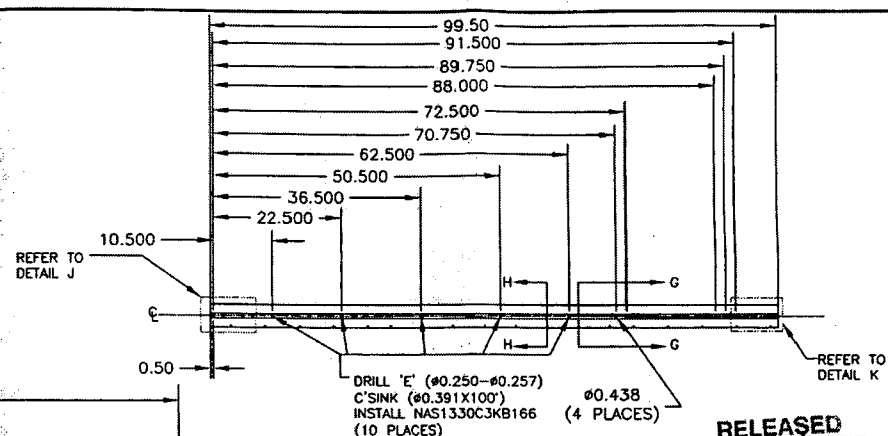
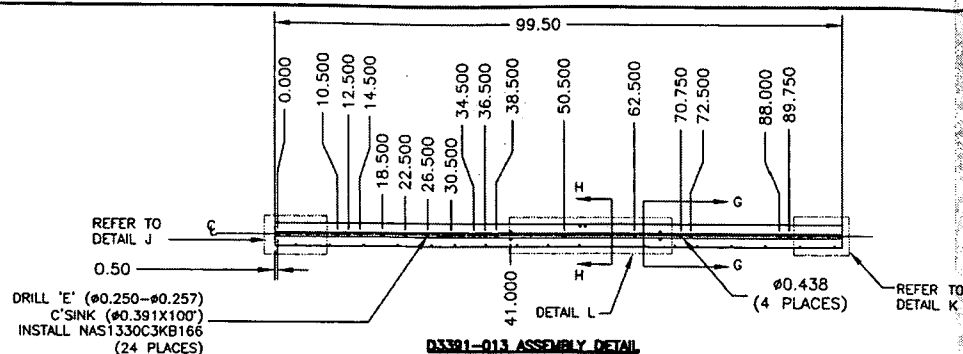
WORK ORDER  
26579

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

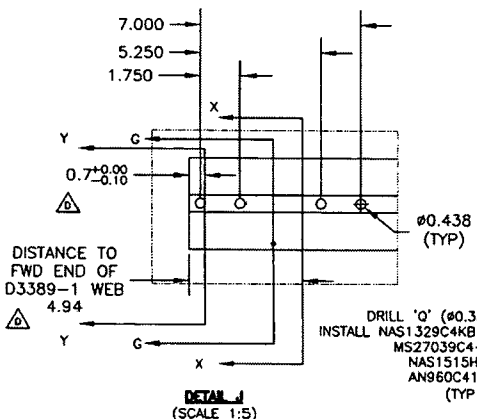
ENGINEERING  
RETURN TO  
HOP COPY



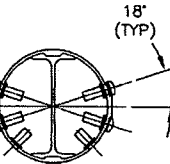
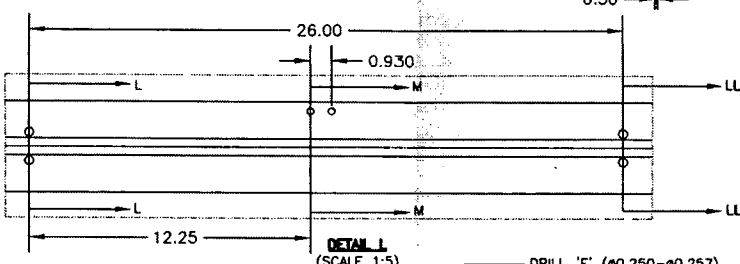
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| DATE<br>06.01.23                             | TITLE<br>412 FLOAT SKIDTUBE |                      |                        |  |



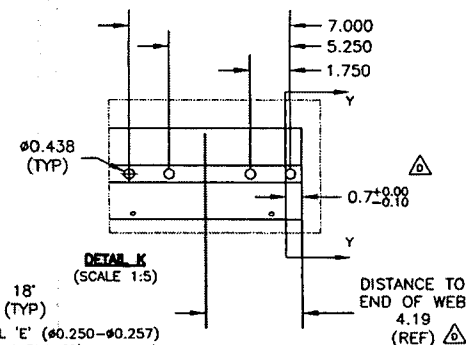
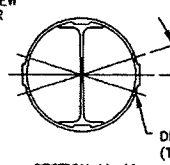
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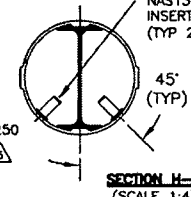
DRILL 'O' (#0.332-#0.338)  
INSTALL NAS1329C4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



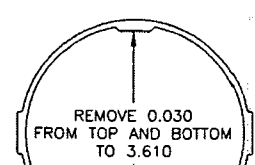
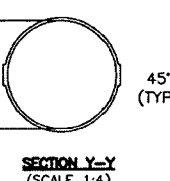
DRILL 'E' (#0.250-#0.257)  
C'SINK (#0.391X100')  
INSTALL NAS1330C3KB116 INSERT  
MS27039C1-09 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 4 PLACES)



NAS1330C3KB116  
INSERT  
(TYP 20 PLACES)



REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)



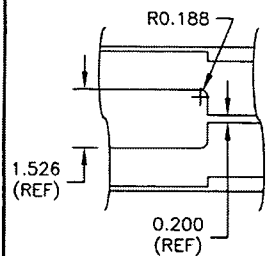
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - 013 | QTY - 023 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         | X         | D3391-013      | MID TUBE ASSEMBLY |
|           |           | D3391-023      | MID TUBE ASSEMBLY |
| 1         | 1         | D2500-1-100    | EXTRUSION         |
| 1         | 1         | D3389-1        | WEB               |
| 24        | 20        | NAS1330C3KB116 | INSERT            |
| 24        | 10        | NAS1330C3KB166 | INSERT            |
| 4         |           | NAS1329C4KB140 | INSERT            |
| 4         |           | NAS1515H3L     | WASHER            |
| 4         |           | AN960C10L      | WASHER            |
| 4         |           | NAS1515H4L     | WASHER            |
| 4         |           | AN960C416L     | WASHER            |
| 4         |           | MS27039C1-09   | SCREW             |
| 4         |           | MS27039C4-08   | SCREW             |

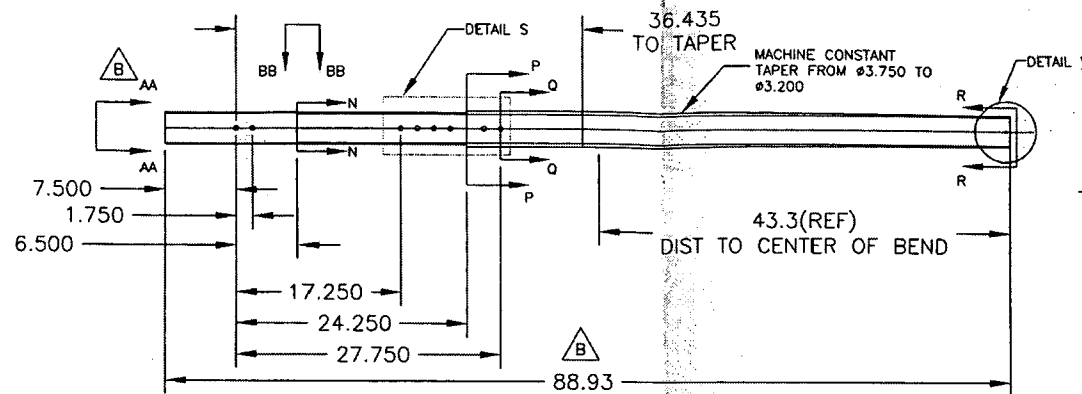
D3391-013/-023 MID TUBE ASSEMBLY  
1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION  
2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX 247-291 PER 015

|   |  |                             |                |  |
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|   |  | TITLE<br>412 FLOAT SKIDTUBE |                | SCALE<br>1:20  |

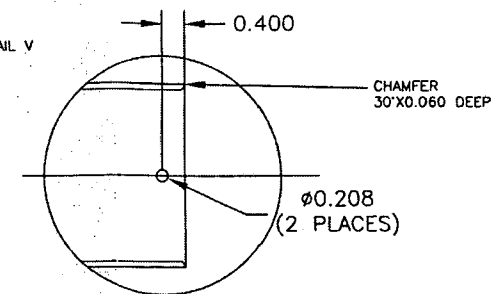
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VIEW BB-BB  
(SCALE 1:3)

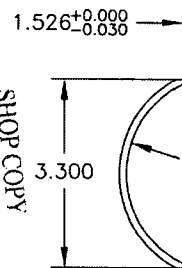


D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

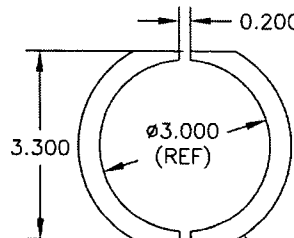


DETAIL V  
(SCALE 1:2)

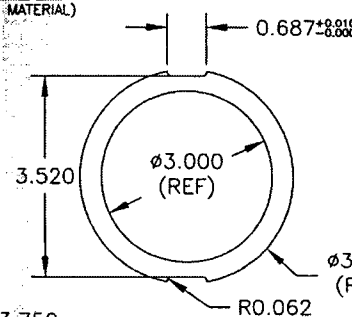
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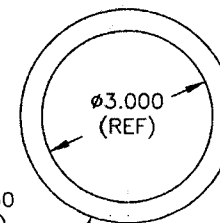
SECTION AA-AA  
(SCALE 1:2)



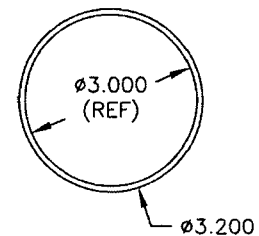
SECTION N-N  
(SCALE 1:2)



SECTION P-P  
(SCALE 1:2)

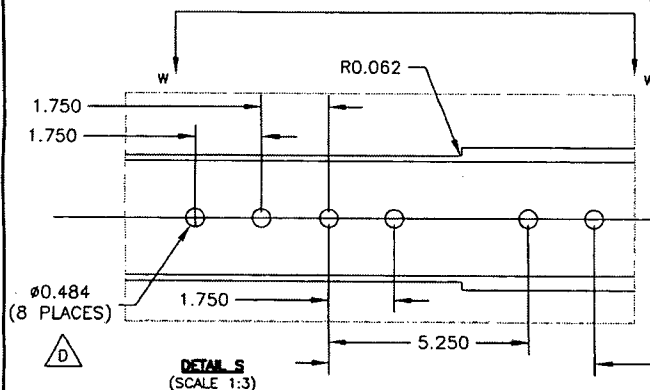


SECTION Q-Q  
(SCALE 1:2)

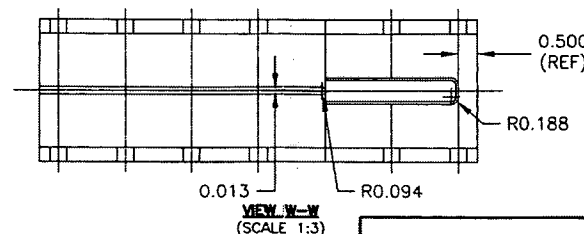


SECTION R-R  
(SCALE 1:2)

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DETAIL S  
(SCALE 1:3)



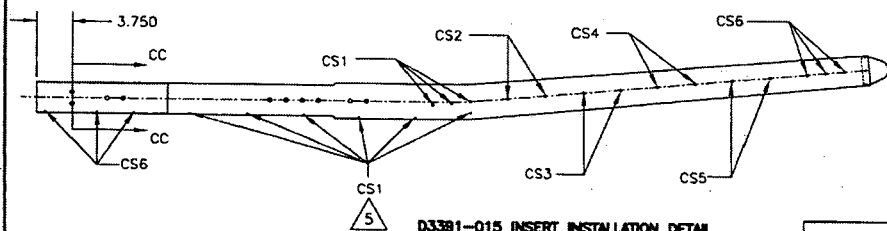
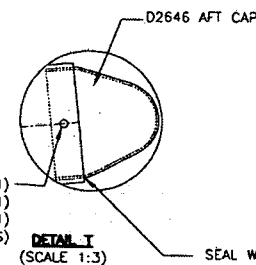
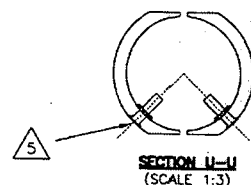
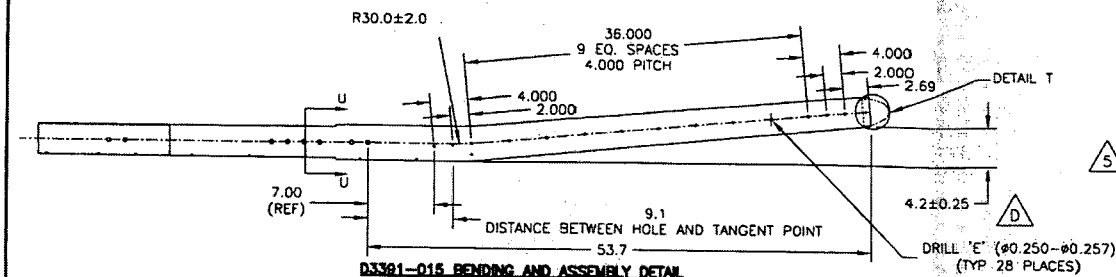
VIEW W-W  
(SCALE 1:3)

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| CHECKED | #        | APPROVED | #                  | DRAWING NO.<br>D3391                                     | SHEET 4 OF 5 |
| DATE    | 06.01.23 | TITLE    | 412 FLOAT SKIDTUBE | SCALE  | 1:12         |

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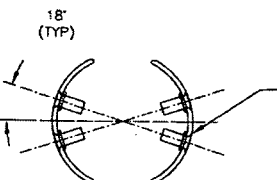
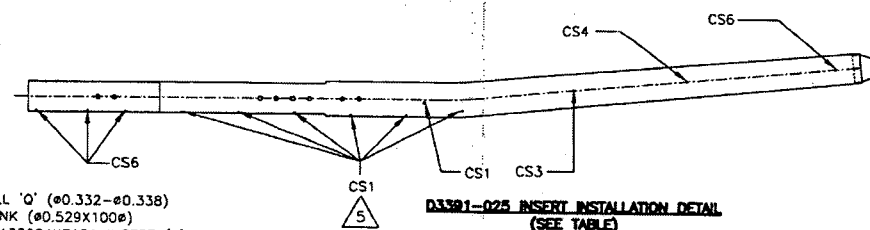
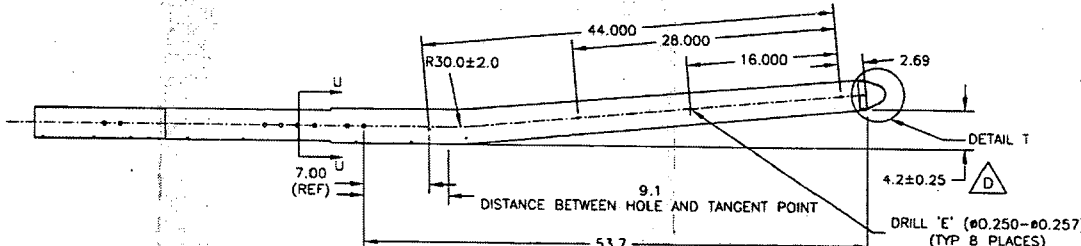


C'SINK AND INSTALL AESS10KBXXX AND/OR NAS1330C3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'SINK | P/N            |
|--------------|---------------|---------------|--------|----------------|
| CS1          | 18            | 14            | Ø0.425 | AESS10KB366    |
| CS2          | 4             |               | Ø0.391 | AESS10KB366    |
| CS3          | 4             | 2             | Ø0.391 | NAS1330C3KB316 |
| CS4          | 4             | 2             | Ø0.391 | NAS1330C3KB266 |
| CS5          | 4             |               | Ø0.391 | NAS1330C3KB216 |
| CS6          | 12            | 8             | Ø0.391 | NAS1330C3KB166 |

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER    | DESCRIPTION       |
|-----------|-----------|----------------|-------------------|
| X         |           | D3391-015      | AFT TUBE ASSEMBLY |
|           | X         | D3391-025      | AFT TUBE ASSEMBLY |
| 1         | 1         | D6014-090      | AFT TUBE          |
| 1         | 1         | D2646          | AFT CAP           |
| 18        | 14        | AESS10KB366    | INSERT            |
| 4         | 2         | NAS1330C3KB316 | INSERT            |
| 4         | 2         | NAS1330C3KB266 | INSERT            |
| 4         |           | NAS1330C3KB216 | INSERT            |
| 12        | 8         | NAS1330C3KB166 | INSERT            |
| 4         |           | NAS1330C4KB151 | INSERT            |
| 2         | 2         | AN3C4A         | BOLT              |
| 2         | 2         | NAS1515H3L     | WASHER            |
| 2         | 2         | AN960C10L      | WASHER            |



DRILL 'Q' (Ø0.332-Ø0.338)  
C'SINK (Ø0.529X100P)  
NAS1330C4KB151 INSERT (1)  
(4 PLACES)

|   |  |                            |                             |  |
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| DATE 06.01.23   |  | TITLE 412 FLOAT SKIDTUBE   |                             | REV. D<br>SHEET 5 OF 5<br>SCALE 1:12                     |

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|----------------------------------|--------|--------------|-----------|
| DART AEROSPACE LTD               |        | Work Order:  | 26579     |
| Description: 412 float skid tube |        | Part Number: | D3391 025 |
| Inspection Dwg: 3391             | Rev: 0 | Page 1 of 1  |           |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance                | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|--------------------------|------------------|--------|--------|----------------------|----------|
| 14.000            | $\pm .010$               | 14.000           | ✓      |        |                      |          |
| 3.500             | $\pm .010$               | 3.496            | ✓      |        |                      |          |
| 88.93             | $\pm .030$               | 88.93            | ✓      |        |                      |          |
| 3.200             | $\pm .01$                | 3.205            | ✓      |        |                      |          |
| 3.300             | $\pm .010$               | 3.294            | ✓      |        |                      |          |
| 1.528             | $\pm .000$<br>$\pm .030$ | 1.524            | ✓      |        |                      |          |
| 0.200             | $\pm .010$               | 0.194            | ✓      |        |                      |          |
| 3.520             | $\pm .010$               | 3.518            | ✓      |        |                      |          |
| 0.687             | $\pm .010$<br>$\pm .000$ | 0.688            | ✓      |        |                      |          |
| R0.062            | $\pm .010$               | R0.062           | ✓      |        |                      |          |
| 7.500             | $\pm .010$               | 7.497            | ✓      |        |                      |          |
| 27.750            | $\pm .010$               | 27.750           | ✓      |        |                      |          |
| 31.750            | $\pm .010$               | 31.750           | ✓      |        |                      |          |
| 35.250            | $\pm .010$               | 35.250           | ✓      |        |                      |          |
| Ø 0.400           | $\pm .010$               | 0.395            | ✓      |        |                      |          |
| Ø 0.484           | $\pm .000$<br>$\pm .001$ | Ø 0.486          | ✓      |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |
|                   |                          |                  |        |        |                      |          |

|                          |                |                     |
|--------------------------|----------------|---------------------|
| Measured by: MS / BG / M | Audited by: En | Prototype Approval: |
| Date: 06/04/21           | Date: 06/05/21 | Date:               |

|     |      |           |            |          |
|-----|------|-----------|------------|----------|
| Rev | Date | Change    | Revised by | Approved |
| A   |      | New Issue | KJ/RF      |          |